

Date: Friday, 6/16/2006 1:41:41 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: END PLATE			
Job Number	: 27591			Part Number	: D30671			
Estimate Number	: 10547			Drawing Number	: D3067 REV A			
P.O. Number	: N/A			Project Number	: N/A			
This Issue	: 6/16/2006 S.O. No. : N/A			Drawing Revision	: A			
Prsht Rev.	: NC			Material	: N/A			
First Issue	: 6/15/2006 Type : MACHINED PARTS			Due Date	: 6/30/2006			
Previous Run	: 26411			Qty:	167			
Written By	: See comment below			Um:	160 Each			
Checked & Approved By	: KJ							
Comment	: Est:03.01.21 Remove step 6 (Deburr)							
Additional Product								
Job Number:								
Seq. #:	Machine Or Operation:	Description :						
1.0	M5052H32S063	5052-H32 .063 Sheet						
		 Comment: Qty.: 0.0656 sf(s)/Unit Total : 10.5000 sf(s) 5052-H32 .063 Sheet Material: 5052-H32 (QQ-A-250/8) M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)						
		Batch: M19296						
2.0	WATER JET	FLOW WATER JET						
		 Dwg Rev <u>A</u> Prog Rev <u>A</u>						
		Comment: FLOW WATER JET						
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE						
		 S40 06-06-20						
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE						
4.0	QC8	SECOND CHECK						
		 S40 06-06-20						
		Comment: SECOND CHECK						
5.0	BRAKE NC	NC BRAKE						
		 1/16/22 - debur as necessary						
		Comment: NC BRAKE						
		Bend as per Dwg D3067						
6.0	QC5	INSPECT WORK TO CURRENT STEP						
		 SB 04/06/26 (166) P.D. H.M. 06-06-22						
		Comment: INSPECT WORK TO NEXT STEP						

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Drawing Name: END PLATE

Job Number: 27591

Part Number: D30671

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



J 06-06-27 166



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

8.0

DC

DOCUMENT CONTROL



166

Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/06/27

Job Completion



U

06-06-27

Date: Thursday, 6/15/2006 1:56:17 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: END PLATE		
Job Number	: 27591					
Estimate Number	: 10547					
P.O. Number	:			Part Number	: D30671	
This Issue	: 6/15/2006	S.O. No.	:	Drawing Number	: D3067 REV A	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: 6/15/2006	Type	: MACHINED PARTS	Drawing Revision	: A	
Previous Run	: 26411			Material	:	
Written By	:			Due Date	: 6/30/2006	Qty: 160 Um: Each
Checked & Approved By	: <u>DK 06.06.15</u>					
Comment	: Est:03.01.21 Remove step 6 (Deburr) KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S063	5052-H32 .063 Sheet	
2.0	SHEAR		
		Comment: SHEAR Cut blanks 2.750" x 3.030" +/-0.005 Grain along 2.750"	N/A
3.0	HAAS1 <i>Water Jet.</i>	HAAS CNC VERTICAL MACHINING #1	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/20	5	I piece was scrap out of tolerance	B 06/06/20	Scrap & destroy	SB 06/06/20 6/06/20			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA:

Date: 06/06/20

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Drawing Name: END PLATE

Job Number: 27591

Part Number: D30671

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
 Comment: NC BRAKE Bend as per Dwg D3067		
7.0	QC5	INSPECT WORK TO CURRENT STEP
 Comment: INSPECT WORK TO NEXT STEP		
8.0	PACKAGING 1	PACKAGING RESOURCE #1
 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
9.0	DC	DOCUMENT CONTROL
 Comment: DOCUMENT CONTROL Inspection Level 21		

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	Z7591
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

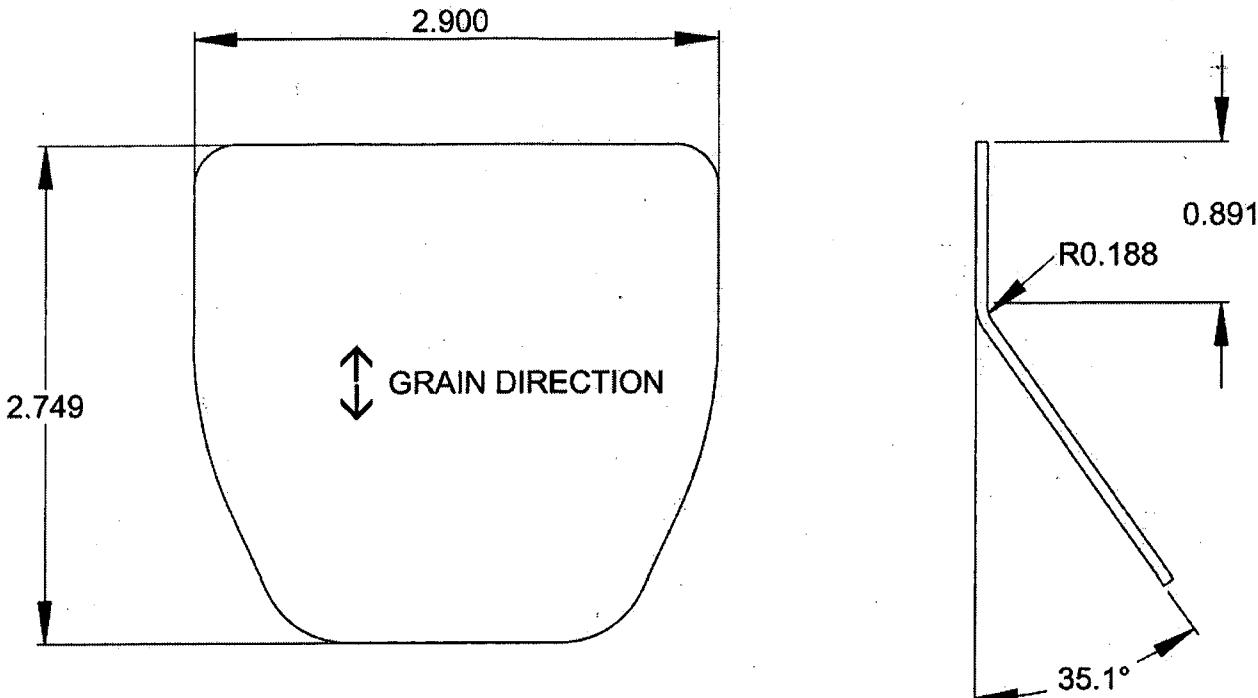
EP, blob 12°

Measured by:	SAD	Audited by:	Er	Prototype Approval:	N/A
Date:	06/06/20	Date:	06/06/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	JF

DART

DESIGN <i>CP</i>	DRAWN BY <i>DP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AA</i>	APPROVED <i>AA</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011D3067-1 FLAT PATTERND3067-1 BEND DETAILD3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO

ENGINEERING

JUN 10 2011

COPIED SUBJECT TO AMENDMENT

NOTICE WITHOUT

WORK ORDER

NO. 27591

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